Work Order ID 66204

February 7, 2011 12:47:10 PM

Item ID: D4198-041
Revision ID: PRELIM
Item Name: Throttle Bellcrank Assembly, LH

Start Date: 2/07/11 **Start Qty:** 2.00
Required Date: 2/18/11 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** CL **Date:** 11/02/07 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4198 / Revision Nbr: ~~PA1~~ PA2									
100	Pick Kit	0.00							
Packaging	**Memo**	0.00	SB 11/04/20			(1)			
Packaging									
110		0.00							
Small Fab	**Memo**	0.00	SB 11/04/20			(1)			
Small Fab	assemble as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00	-inspection to PA2 Dwg only						
QC	**Memo**	0.00							
Quality Control			SB 11/07/20 QC						

POSITIVE RECALL

PRELIMINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 66204

February 7, 2011 12:47:10 PM

Item ID: D4198-041 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Throttle Bellcrank Assembly, LH

Start Date: 2/07/11 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 2/18/11 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: Rack Shelf	0.00							
Packaging	**Memo**	0.00	11-04-20			10			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

RD 2334

R11-069 (1)

POSITIVE RECALL
EFFECTIVE 11-02-07 AUTH
RELEASED _____ DATE _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

February 7, 2011 12:47:09 PM

Work Order ID: 66204

Parent Item: D4198-041

Parent Item Name: Throttle Bellcrank Assembly, LH

Start Date: 2/07/11 **Required Date:** 2/18/11

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A NEW ISSUE 10-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4198-1 Tube, LH		Manufactured	No		B66210	100	Each	0.0000	1	2	SA	11/04/20	
D4198-5 Bellcrank		Manufactured	No	B66047		100	Each	0.0000	1	2	SA	11/04/20	
~~MS20470AD4-20~~ Rivet		Purchased	No			100	Each	542.0000	2	4	SA	11/04/20	

105768

CR3523-4-4

Location	Loc Qty	Loc Code
ST320	542	
1071	542	

4

11.04.20

Batch: 10-00815 (EAGLE)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

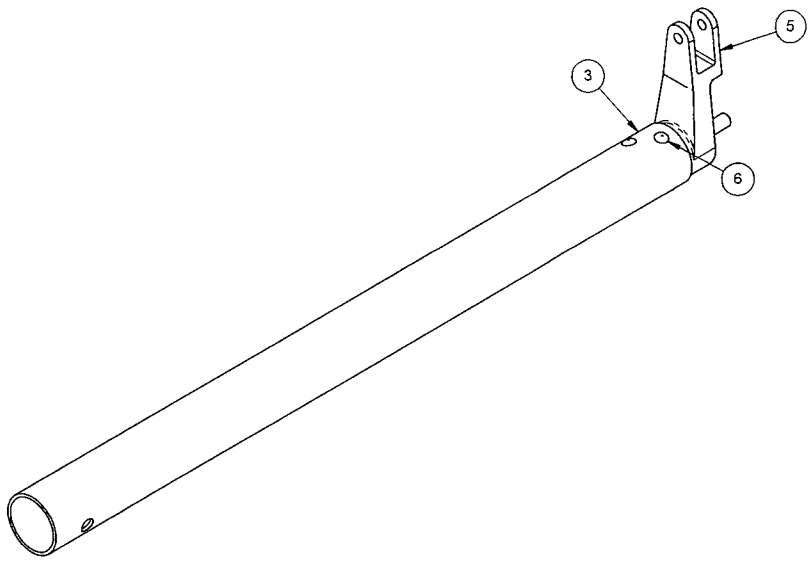
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

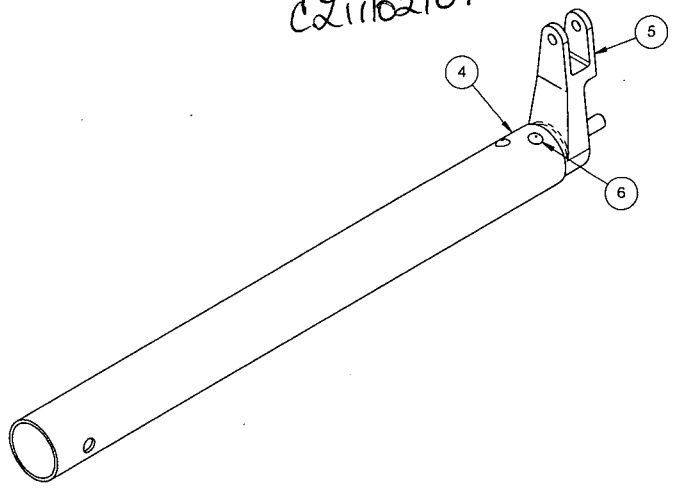
NOTE: Date & initial all entries

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4198-041	LH THROTTLE BELLCRANK ASSEMBLY
2		X	D4198-043	RH THROTTLE BELLCRANK ASSEMBLY
3	1		D4198-1	TUBE, LH
4		1	D4198-3	TUBE, RH
5	1	1	D4198-5	BELLCRANK
6	2	2	MS20470AD4-20	RIVET

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D4198-041 LH THROTTLE BELLCRANK ASSEMBLY



D4198-043 RH THROTTLE BELLCRANK ASSEMBLY

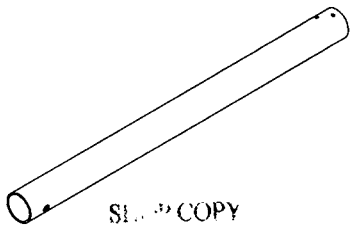
PRELIMINARY ISSUE
10.11.03

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: (-041) 1.28 lbs
(-043) 1.10 lbs

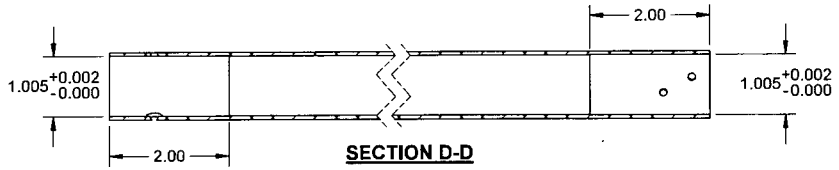
REV.	DESCRIPTION	BY	DATE
PA2	NEW ISSUE		10.11.03

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CHECKED		DRAWING NO. D4198 REV. PA2 SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE THROTTLE BELLCRANK SCALE NTS
DE APPR.		
DATE	10.11.03	

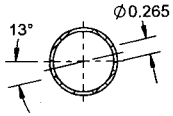
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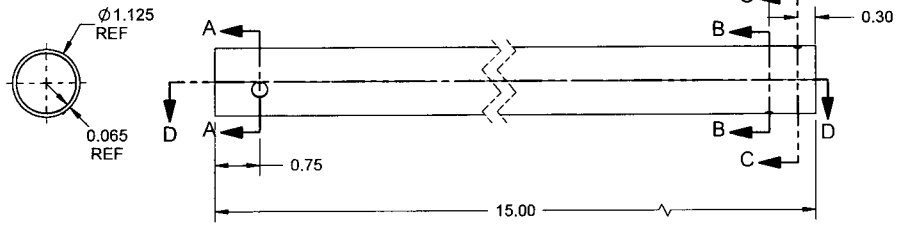
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NO. 66204

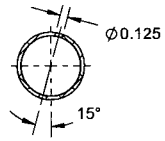


SECTION D-D

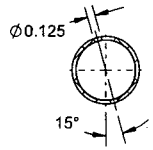


SECTION A-A





SECTION B-B



SECTION C-C

D4198-1 TUBE, LH

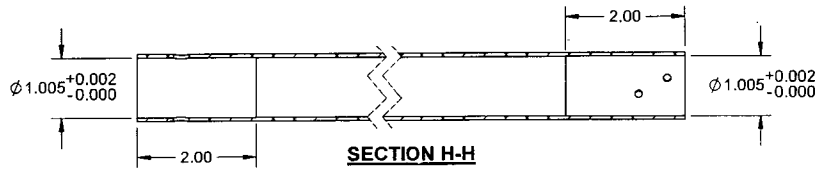
PRELIMINARY ISSUE

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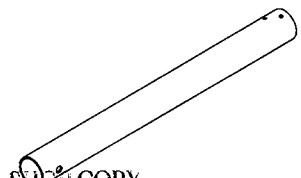
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, OD Ø1.125 X 0.065 WALL THICKNESS
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC M304TR1.158W.049
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.91 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
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CHECKED		DRAWING NO. D4198 REV. PA2 SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE THROTTLE BELLCRANK SCALE NTS
DE APPR.		
DATE	10.11.03	

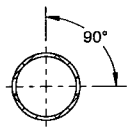
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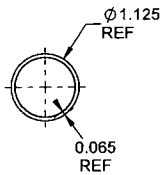


SECTION H-H

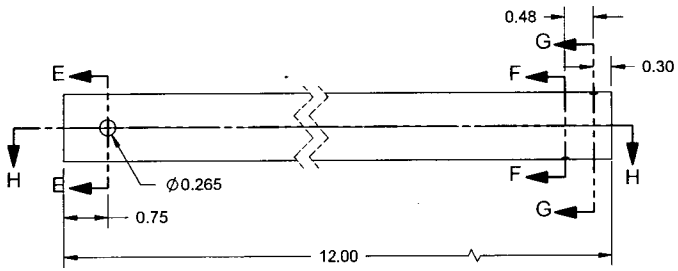


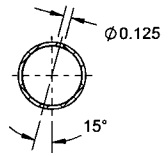
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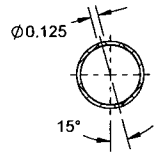


SECTION E-E





SECTION F-F



SECTION G-G

D4198-3 TUBE, RH

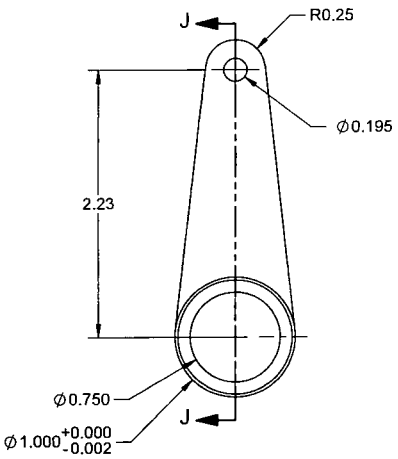
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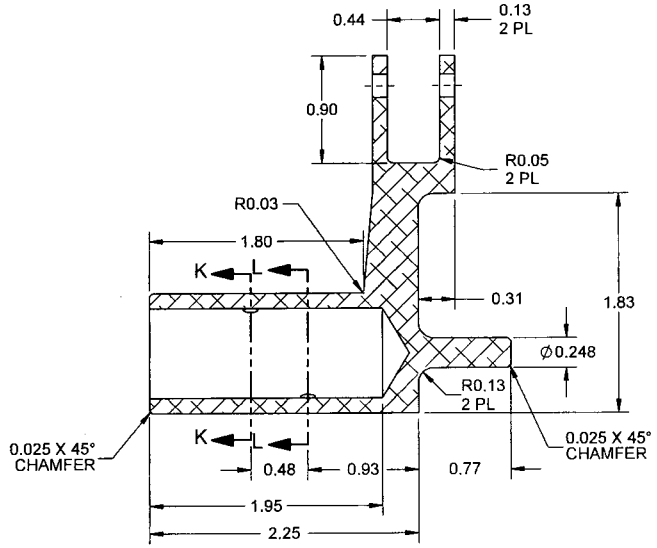
10.11.03

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, OD Ø1.125 X 0.065 WALL THICKNESS
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC M304TR1.158W.049
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.71 lbs

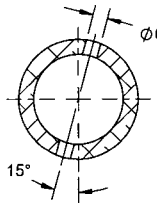
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CHECKED		DRAWING NO. D4198 REV. PA2 SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE THROTTLE BELLCRANK SCALE NTS
DE APPR.		
DATE 10.11.03		

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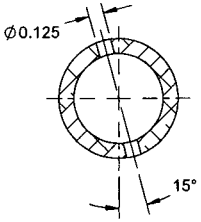




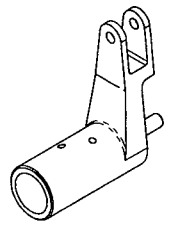
SECTION J-J



SECTION K-K



SECTION L-L



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D4198-5 BELLCRANK

PRELIMINARY ISSUE

10.11.03

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF DART SPEC M304B
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4198 REV. PA2 SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE THROTTLE BELLCRANK SCALE NTS
DE APPR.		
DATE	10.11.03	

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